



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

URGENT

RB T101873-63
Job Sheet 194672



Part No: RB T101873-63

Job Qty: 1 pcs

Part Name: Press



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Due Date: 5/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T101873 Rev. D IPP Rev. A 18.09.06 New issue DP Verify DD/IPP Rev. B 19.05.01 drawing revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Rework - 1 - Startup	1 pcs	5/24/19	5/24/19	0.00	0.00	Rework		<i>19.05.07</i>
							Packaging 1 - 1		
110	SL-154 - 1	1 pcs	5/24/19	5/24/19	0.00	0.25	SL-154 - 1		
120	QC 2	1 pcs	5/24/19	5/24/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S178680



Part: RB T101873-63

Job No: 194672

Serial No/Batch: S178680

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 05/15/19

130 QC 8

1 pcs

5/24/19

0.00 0.00

QC 2 - 66

QC 2 - 64

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

135 Outsource - 1 - Heat Treat

1 pcs

5/24/19

-ME1001 VC

ATL002

HY 2019-05-07

136 Packaging 2-1 - Receive - B4B

1 pcs

5/24/19

0.00 0.00

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

Packaging 2 - 3 - B4B

Packaging 2 - 5 - B4B

Packaging 2 - 4 - B4B

Packaging 2 - 6 - B4B

Packaging 2 - 7 - B4B

Packaging 2 - 8 - B4B

Packaging 2 - 9 - B4B

Packaging 2 - 10 - B4B

Packaging 2 - 11 - B4B

Packaging 2 - 12 - B4B

Packaging 2 - 13 - B4B

Packaging 2 - 14 - B4B

Packaging 2 - 15 - B4B

Packaging 2 - 16 - B4B

Packaging 2 - 17 - B4B

Packaging 2 - 18 - B4B

Packaging 2 - 19 - B4B

Packaging 2 - 20 - B4B

Packaging 2 - 21 - B4B

Packaging 2 - 22 - B4B

Packaging 2 - 23 - B4B

Packaging 2 - 24 - B4B

Packaging 2 - 25 - B4B

Packaging 2 - 26 - B4B

Packaging 2 - 27 - B4B

Packaging 2 - 28 - B4B

Packaging 2 - 29 - B4B

MAY 15 2019

					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
138	QC 6	1 pcs	5/24/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	MAY 15 2018
					QC 6 - 61	9-89
					QC 6 - 40	
140	Outsource - 12 - Black Oxide	1 pcs	5/24/19		GRO002-VC	
150	Packaging 2-2 - Receive - B4B	1 pcs	5/24/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160	QC 6	1 pcs	5/24/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
210	Packaging 3-1 - Stock - B4B	1 pcs	5/24/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	

WLA
 per Mike Lee
 → Uzae signal
 all
 oil part!

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	1 pcs	5/24/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 MAY 15 2019
				QC 21 - SA - 53	9-89

Part Op 110 - SL-154 (MORI SL-154 LATHE) 1-Machine as per DWG. FC _____ FOLIO REV: _____ DWG REV: _____

Descriptions: 2-Deburr

120 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8 Machining-4 (QC8- Inspect parts - second check) Engrave dash number only using MARKTRONIC engraver as per DWG.

135 - Outsource1 (Outsource process - Heat Treat) 1--Issue P/O; P/O _____ RC 48-52 2-Bead blast 3- Certificate of Conformity is required

136 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

138 - QC6 (QC6- All purchased or subcontracted products)

140 - -Issue P/O; _____-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required

150 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

160 - QC6 (QC6- All purchased or subcontracted products)

210 - Packaging3-1 (Identify as per dwg & Stock Location: _____)

220 - QC21 (QC21- Final Inspection - Work Order Release)

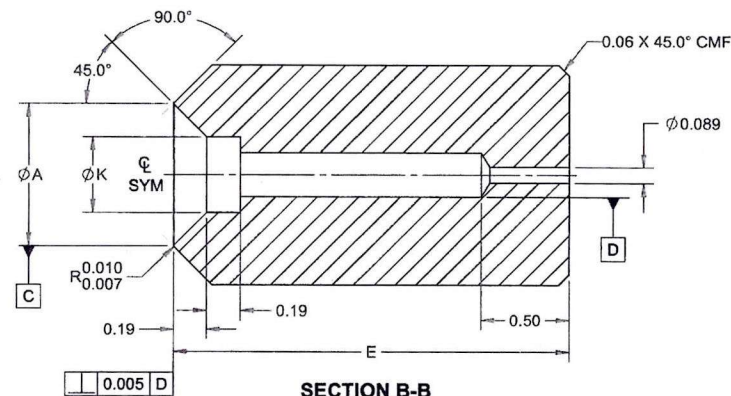
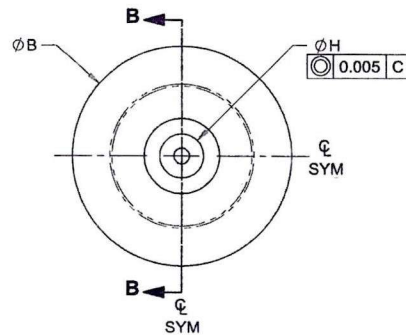
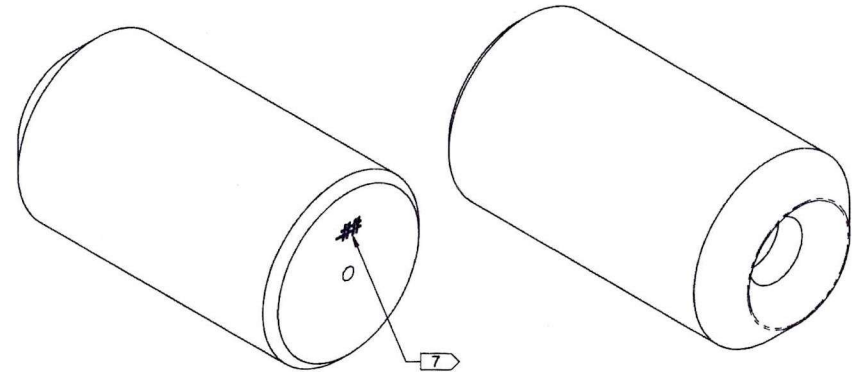
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RB T101873-63	Press	1 pcs (1 ea)	90-Rework - 1 - Startup	5178644

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Rework - 1 - Startup	RB T101873-63	1	1	0

Part Specifications	
Specifications could not be found.	

**TABLE 1
PRESS**

PART #	DIMENSION A ±0.0025	DIMENSION B	DIMENSION E ±0.03	DIMENSION H +0.0008/-0.0000	DIMENSION K
RB T101873-39	0.8085	1.250	2.25	0.2500	0.429
RB T101873-45	0.8422	1.250	2.00	0.1800	0.462
RB T101873-51	0.8752	1.250	2.00	0.3125	0.495
RB T101873-57	0.9377	1.500	2.25	0.3750	0.558
RB T101873-63	0.9377	1.500	2.25	0.3125	0.558
RB T101873-69	0.9692	1.500	2.00	0.2500	0.589
RB T101873-75	1.1257	1.500	2.25	0.3750	0.746
RB T101873-81	1.1877	1.500	2.75	0.5000	0.809
RB T101873-87	1.3127	1.750	2.25	0.3125	0.933



RB T101873-39, -45, -51, -57, -63, -69, -75, -81, -87 PRESS

NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: RC 48-52
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE DASH # ONLY, AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194672MLS
90507

DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB T101873 TITLE RING STAKING TOOL SCALE NTS	REV. D
DRAWN	MBB		SHEET 4 OF 9
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	VP	DATE	4/30/2019

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043400



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043400

PO Date: 5/7/19

Due Date: 5/9/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments: ****RUSH RUSH RUSH****

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194672	RB T101873-63	Press Outsource1 (Outsource process - Heat Treat) 1-Issue P/O; P/O _____ RC 48-52 2-Bead blast 3- Certificate of Conformity is required 4. Material 01	Firmed	-	5/9/19	1 pcs	0 pcs	1 pcs	\$75.00/pcs	\$75.00

1X

MAY 15 2019

DAS
68
9-89

Grand Total: \$75.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/14/19 12:53 PM Dart.Guerin.Kimberley

Shipping Ticket

Sold To: 1448**DART AEROSPACE LTD.**
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 163089**DART AEROSPACE LTD.**
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB043400 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
✓ 1	PC MATERIAL 01 SANDBLAST AND HEAT TREAT TO 48-52RC C OF C, PRT# RBT101873-63, JOB# 194672 ✓	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

1

Pounds Shipped:

1.00

RECEIVED

MAY 14 2019

DART AEROSPACE LTD.48 RC ^{AB}

5-13-19

Order No.: 166154

Shipped Complete

Quantity Shipped:

1.00

Received By:

Date:

Pounds Shipped:

1.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 05/10/2019

Certification

Date: 05/13/2019

Entry Date: 05/10/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB043400 ✓

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
1	1 PC MATERIAL 01 SANDBLAST AND HEAT TREAT TO 48-52RC C OF C, PRT# RBT101873-63, JOB# 194672 ✓	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
------------	-------	---------	---------	--------	-------

Customer Requirements:

Harden rockwell

Results:

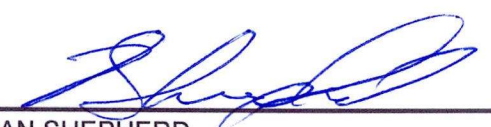
Harden ROCKWE 48. 52. 48. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 48 RC AS PER CUSTOMER REQUEST

DAS
68
9-89

48-49 HRC

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

1930657

11551M

June 15

21 x 15

June 27

22 x 14

1930654

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88-0